

## Sheet Metal Stepdrill Ø6 - Ø30

A06-200

The spiral flute of the sheet metal stepdrill is ground in 4 passes of each 0.6 mm increment plus 2 additional fast sparkout passes. The vitrified wheel for fluting has to be dressed after each 5 pieces. The O.D. is ground step by step in one pass (overmeasure around 0.1 to 0.3 mm)



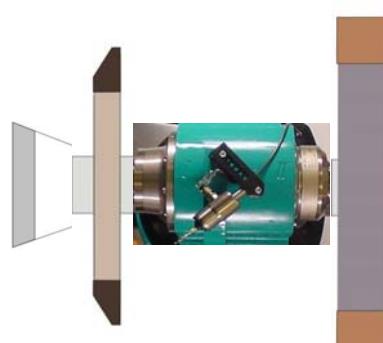
### 1. Cycletime for Production

Workpiece: Ø 6 - 30 mm, Z 2, Length 70 mm, Helix angle 25° Material HSS							
Operations	Probe	Flute 1	Gashing	End 2	End 1	O.D. Radial	Dress
Feed [mm/Min]	2000	900	100	70	100	350	150
Power [kW]		8	2	1	1	2	2
Cutting speed [m/s]		48	32	32	32	32	32
Used wheels		1	2	3	3	2	1
Grinding time [s]	8	215	28	32	28	166	41
Total cycle time	8 Min 54						

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	1A1 Ø200 B20 C120
2	1V1 Ø150 B106 V45°
3	11V9 Ø100 B126



3 2

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### 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR

Coolant: Synthetic Oil, pressure 16 bar

Control: Fanuc 31i

Software: Quinto 5

Accessories: Dressing

Responsible engineer: OP. 2.4.12

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